

Date: Wednesday, 5/23/2007 3:24:23 PM
 User: Kim Johnston

Process Sheet

SPLIT-

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PLUG	
Job Number	: 32466		Part Number	: D26511 <i>up</i>	
Estimate Number	: 10512		Drawing Number	: D2651 REV. B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 5/23/2007 S.O. No. : N/A		Drawing Revision	: B	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 6/6/2007	
Previous Run	: 32118		Qty:	200	Lm: Each
Written By					
Checked & Approved By					
Comment	: Est: A 02.04.15 New Issue NG				
	Est: B 05.12.12 added deburr EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R0500	6061-T6 Round Bar 500"
		 Comment: Qty.: 0.0421 f(s)/Unit Total : 8.4210 f(s) <i>M104619 8.7" [7.25]</i> Material: 6061-T6 (QQ-A-225/8) 0.500" Dia <i>(M6061T6R0500)</i> Batch: <i>M103961 28" [2.3]</i>
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
		 <i>QC 07/06/07</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 <i>X720</i>
		 <i>QC 07/06/07</i>
4.0	QC8	SECOND CHECK
		 <i>QC 07/06/07</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 <i>ml07/06/07</i>
		 <i>ml07/06/07</i>
		 <i>ml07/06/07</i>

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6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

111

07-07-17

130

7.0 POWDER COATING

POWDER COATING



~~Self Etch Blue + clear~~



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(Only larger section necessary)

~~Self Etch Blue + clear~~

~~Atelox Detox 700~~

(132)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

~~stock unsuited in~~

~~stores~~
(130)

(1)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



(134)

Comment: FINAL INSPECTION/W/O RELEASE

~~05/23/07~~

Job Completion



~~05/23/07~~

DART AEROSPACE LTD	Work Order:	324160
Description: Plug	Part Number:	D2651-1
Inspection Dwg: D2651	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

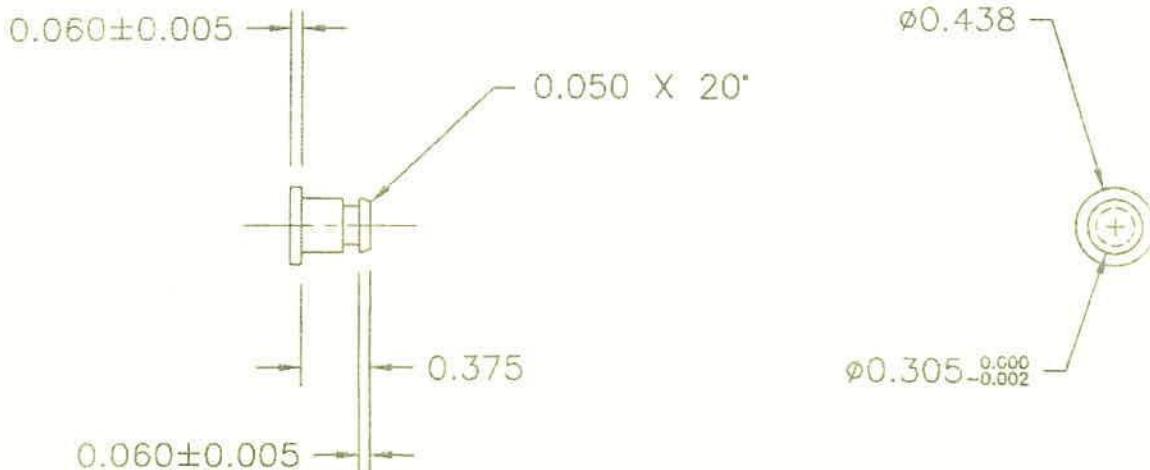
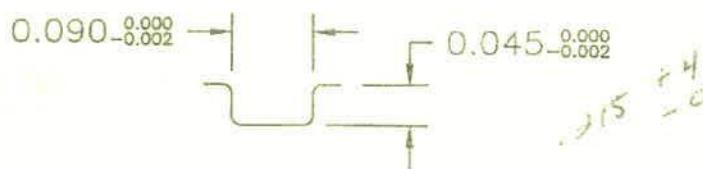
X First Article Prototype

Measured by:	<i>RD</i>	Audited by:	<i>MS</i>	Prototype Approval:	N/A
Date:	<i>07/06/20</i>	Date:	<i>07/06/20</i>	Date:	

Rev	Date	Change	Revised by	Approved
A	03.12.22	New Issue	KJ/RF	TT

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2651	SHEET 1 OF 1
DATE		TITLE	SCALE
03.12.19		PLUG	1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

RELEASED03.12.19 *dh*D2651-1 PLUG:GROOVE DETAIL (SCALE 5:1)D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

SHIPPING
RECEIVED
ENTERED
UNCAUTHERED
SUBJECT
REVIEWED
APPROVED
NO. 32466

